Work Order ID 1 July-09-13 11:39:56 AM			*104200*									
Item ID: D4016-1 Revision ID:	·	A	Accept	*N900040	100*	Setup	Start	*NS	1*			
Item Name: Hinge Half,	Base						Stop	*NS	2*			
Start Date: 7/09/13 Required Date: 7/09/13 Reference:	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item ID: Customer:					·			
Approvals: Process I	Plan: MLJ	Date: 13-07-12  Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR *NR	1* 2*			
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID Tool #	Plan Acc Code Qty	-	•	•	isp. tamp			
Draw Nbr R	evision Nbr											
* D4016 A 100 * 100 * Bandsaw Jeaspa Bandsaw	Cut blanks as per folio  Memo	K 1.00" LONG	0.00		Q	<u> </u>		  	_13-7-2			
*110  *110*  HAAS 1  HAAS CNC vertical machine #1	<b>Memo</b> MACHINE . FOLIO REV DWG REV:	AS PER FOLIO FA869 AN	0.00 0.00 D DWG	°C 2013-01-24				<u>\</u>	1272			

DEBURR

DQA:		_ Date:										TO AC
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPI		ork Order up	odate only	AEROSPACE
					DISPOSITION				•	EPARTMENT,		
Work Orde	er:				_				_	· · · · · · · · · · · · · · · · · ·	·	
Part N	ام				Rework			Skid-tube	Crosstube	-	Water Jet	Engineering
raiti	····				Scrap Use-as-is		1	Machining	Small Fab	-	d. Eng. Coor.	Quality
NCR N	lo.				Suspected Unapproved		mem	noforming Large Fab	Finishing Composite	Recystor	re/Packaging Supplier	Other
,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,					Suspected Onapproved			Large rab	Composite		3dphilei [	_
Root				Desci	ription of work order update		Initial	Actio	on	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descrip	otion	Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre		-										
Material						ļ						
Operator												
Offset/Setup												
Process												
Supplier												
Training						ŀ						
Transport												
Unapproved												
						FAL	ULT CA1	EGORY				
Landir	ng Gear				General		_					
	Bendin	3			Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
	Centre	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ct [	Temperature/Cure
	Crimp/I	(ink/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Unq	ualified	Part Lost/Mi	ssing	Weld
	Cuffs	•			Contamination		Instruct	ions Incomplete/Un	ıclear	Part Moved		Wrong Stock Pulled
	Crushin	g			Countersink		Misalig	ned/off center		Positioned V		_
	Heat Tr	eat			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other
	Inspect	on Strip in	Tube		Drawing		Misread	i	-	_		
	Marks/	Chatter			Drill Holes		Off-set					
	Turning	Sequence			Finish		Out of 0	Calibration				
	Wave/1	wist in Tul	oe .		Fit/Function		Out of S	Sequence				

. 4	ork Order ID 104200 -09-13 11:39:56 AM		*104200*										Page 2
Item ID:	D4016-	1 .		Accept		*N900	040	100	)*	Setup	Start	*N:	S1*
Revision ID: Item Name:	Hinge H	alf, Base									Stop		S2*
Start Date: Required Date: Reference:	7/09/13 : 7/09/13	<b>Start Qty:</b> 20.00 <b>Req'd Qty:</b> 20.00	*20* *20*			Cust Item I Customer:	ID:						
Approvals:	Proces	s Plan:	Date:	Tooling		D	ate:	_		Run	Start	*N	R1*
			Date:				ate:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set I Run	Up/ Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Re Qt	•	Reject Number	Insp. Stamp
120		QC2- Inspect parts off m	achine FAI/FAIB	0.00									
*120* QC Quality Control		Memo		0.00	SFC	2013-07-2	· 4.						<u> </u>
130		QC8- Inspect parts - seco	and check	0.00	~AS								
*130* QC Quality Control		Мето	,	0.00	9-8	13/07/	25		20		<b>F</b>		·
: 2													
160		Identify as per dwg & Sto	ock Location: WACC	0.00					10		sel s	11 17	
*160* Packaging		Memo		0.00					aU;	<u>x</u> _	<u>"//</u> ./	V. 13.	07-26

Memo

Packaging

DQA:	A: Date:			<u>_</u>	WORK ORDER NON-	c	NIEOI	DNANICE / LIDDA	TC.			DART
QA Closed:		Date:			WORK ORDER NON-	-((	JINFUI	RIVIAINCE / OPDA		ork Order up	date only	AEROSPACE
Work Orde	ır.				DISPOSITION			A	AGAINST DE	PARTMENT,	PROCESS	
WOIK OIGE	··· ——	,			Rework	1		Skid-tube Cr	rosstube	]	Water Jet	Engineering
Part N	lo				Scrap			<b>—</b>	mall Fab	Pro	d. Eng. Coor.	Quality
	···-	<del></del>			Use-as-is			ı —	Finishing	4	e/Packaging	Other
NCR N	10.				Suspected Unapproved			· —	mposite		Supplier	1
	<u> </u>					J				J		
Root				Desc	ription of work order update		nitial	Action		Sign &		
Cause	Dat	e Step	Qty		or non-conformance	Ch	ief Eng	Descriptio	n	Date	Verification	QC Inspector
Design					·							
Doc/Data						1						
Equip/Tooling												
Handling/Pre												
Material												
Operator												
Offset/Setup			ŀ									
Process				:		l						
Supplier						1						
Training			•									
Transport					•							
Unapproved												
						FA	ULT CA	TEGORY				
Landi	ng Gear				General	_	,			-		7
	Bendi	ng			Bend		1	Program		Outside Dim	ensions	Pressure/Forced
	Centr	e Not Conce	entric	<u> </u>	BOM/Route	L	Grain			Over/Under	tolerance	Set-up
	Crack				Broken/Damage/Defect		Hardwa	are		Part Incorred	t	Temperature/Cure
	Crimp	/Kink/Rippl	e/Wave		Burrs	<u></u>	Inspect	ion Incomplete/Unquali	ified	Part Lost/Mi	ssing	Weld
	Cuffs			_	Contamination	$\vdash$	4	tions Incomplete/Uncle	ar	Part Moved		Wrong Stock Pulled
	Crush	-			Countersink		1 1	gned/off center		Positioned V		<b></b> 1
	Heat				Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	_	ction Strip ir	n Tube		Drawing		Misrea	d				
	Mark	s/Chatter			Drill Holes		Off-set				· · · · · · · · · · · · · · · · · · ·	
	_	ng Sequence			Finish	L	Out of	Calibration		·····		
	l lwave	/Twist in Tu	he		Fit/Function	1	Out of	Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Ord July-09-13 11:				*104	1200*							Page	3
Item ID: Revision ID: Item Name:	D4016-			Accept	*N900	<u>040</u>	100	)*	Setup	Start Stop	. •	S1* S2*	1
Start Date: Required Date: * Reference:	7/09/13 : 7/09/13	- •	*20* *20*		Cust Item l Customer:	ID:							
Approvals:	Proces QC: _	s Plan:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	1/7	R1* R2*	4 4
Sequence ID/ Work Center I 170 * 1 7 0 * QC Quality Control	D	Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	Q1	13 <sub>1</sub>	Reject Number	Insp. Stamp	7

DQA:			Date:										*\DART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		Work Order เ	indate only	AEROSPACE
QA Closed.			Date.									<u> </u>	
Work Orde	er:					DISPOSITION				AGAINST (	DEPARTMEN	T/PROCESS	
	_				_	Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	۷o.					Scrap			Machining	Small Fab	Pr	od. Eng. Coor.	Quality
	_	"				Use-as-is		Thern	noforming	Finishing	Rec/Ste	ore/Packaging	Other
NCR f	No					Suspected Unapproved			Large Fab	Composite [		Supplier	
	•		I	I I				1			G: 0		
Root		D-4-	Chara		Desci	ription of work order update	1	nitial		tion	Sign &	\/	061
Cause	-+	Date	Step	Qty		or non-conformance	Cn	iief Eng	Descr	ription	Date	Verification	QC Inspector
Design Doc/Data	Н		ŀ										
Equip/Tooling	Н												
Handling/Pre	H												
Material	Н												_
Operator	H						1						
Offset/Setup	П								:				·
Process	П												
Supplier	П												
Training	П											·	
Transport							l						
Unapproved							Ì						
							FA	ULT CA	TEGORY				
Landi	ng G	ear				General				_		_	
	Ш	Bending				Bend		Folio/F	Program		Outside Di	mensions	Pressure/Forced
	Ц	Centre N	ot Concer	ntric		BOM/Route		Grain		1	Over/Unde	r tolerance	Set-up
	Щ	Cracks				Broken/Damage/Defect		Hardwa	ire	1	Part Incorr	ect	Temperature/Cure
	Ц	Crimp/Kii	nk/Ripple	/Wave		Burrs	L	Inspect	ion Incomplete/Ur	nqualified	Part Lost/N	Missing	Weld
	-	Cuffs				Contamination		-}	tions Incomplete/l	Unclear	Part Move	d [	Wrong Stock Pulled
	$\vdash$	Crushing				Countersink		Misalig	gned/off center	[	Positioned	Wrong	
	-	Heat Trea				Cut Too Short	L	Mislabe	eled		Power Loss	s/Surge	Other
	$\vdash$		n Strip in	Tube		Drawing	L	Misread	d				
	$\vdash$	Marks/Cl				Drill Holes	L	Off-set					
	$\vdash$	_	equence			Finish	L	4	Calibration			1 1	
	1 1	Wave/Tw	ist in Tub	e e		Fit/Function	1	Out of	Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

July-09-13 11:39:56 AM

Work Order ID:

104200

Parent Item:

D4016-1

Parent Item Name:

Hinge Half, Base

**Start Date:** 7/09/13

Required Date: 7/09/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY:DD

IPP Rev:B as per dwg REV.A DD

10.02.22	verified by EC
10 07 77	verified by EU

	10.02.22 Vernied	by.DC				····							
Component Item ID/	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000 304 bar 1.00 x 1.00		Purchased	No			100	f	14.7000	0.08	1.6	بالا	13-7-6	20
t t				<b>Location</b>		Loc Qty	<u>Lo</u>	c Code					
				MAT050		14.7							
				125	340	2.6			<del></del>				
				MI	26097	12.1			1.6	S			

DQA:			Date:			WORK ORDER MON							*DART
QA Closed:			Date:			WORK ORDER NON-	-C(	JNFOI	RIMANCE / UI		ork Order up	odate only	AEROSPACE
Work Orde						DISPOSITION					PARTMENT	· · · · · · · · · · · · · · · · · · ·	
WORK Orde	٠٠. <u></u>				_	Rework			Skid-tube	Crosstube	7	Water Jet	] [
Part N	do.					Scrap	1		Machining Machining	Small Fab	Pro	d. Eng. Coor.	Engineering Quality
7 41 ( 1	···—				-	Use-as-is			noforming	Finishing		re/Packaging	Other
NCR N	No.					Suspected Unapproved		1110111	Large Fab	Composite	1 1100/3101	Supplier	
			· · · · ·			·	<b>'</b>				_1		البا
Root					Descr	ription of work order update	!	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre	Ш												
Material													
Operator													
Offset/Setup													
Process	Ш												
Supplier													
Training	Ш												,
Transport	Щ												
Unapproved													
						······································	FAI	ULT CAT	regory				
Landii						General		1 .		<del></del>	7	_	7
		nding				Bend		1	rogram	<u></u>	Outside Dim	<u> </u>	Pressure/Forced
	_		t Concer	ntric	$\vdash$	BOM/Route		Grain			Over/Under	<del></del>	Set-up
	_	acks				Broken/Damage/Defect	_	Hardwa			Part Incorred	<del>                                     </del>	Temperature/Cure
	_		ık/Ripple	/Wave	$\vdash$	Burrs		i `	on Incomplete/Ur	·	Part Lost/Mi	ssing	Weld
	L Cu				<u> </u>	Contamination		1	ions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled
	_	ushing			<u> </u>	Countersink	_	1 -	ned/off center	·	Positioned W		7
	$\vdash$	at Trea			<u> </u>	Cut Too Short	_	Mislabe		· <u>L</u>	Power Loss/	Surge	Other
	_		Strip in	Tube		Drawing		Misread	i				
		arks/Ch				Drill Holes	_	Off-set					
	<del></del>	_	equence		<u> </u>	Finish	<u> </u>	1	Calibration				
	l IW	ave/Tw	ist in Tub	e	- 1	Fit/Function	1	Out of 9	Sequence				

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		CONTRACTOR OF THE PARTY OF THE
DART AEROSPACE LTD	Work Order:	104700
Description: Hinge Half, Base	Part Number:	D4016-1
Inspection Dwg: D4016 Rev: A		Page 1 of 1

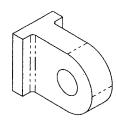
## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.875	+/-0.010	0.875	V		MR	J4602
0.25	+/-0.030	0-243	<b>V</b>		Caliper	0/2-01
0.38	+0.030/-0.000	0.390			l'	1.
R0.03	+/-0.030	RO.030			Radb	JH
0.13	+/-0.030	0.124	✓.		Celipa	JFC-01
0.88	+/-0.030	0.878			. (	(,
Ø0.257	+0.006/-0.001	0.258	<i>\( \( \)</i>		n	• (
R0.38	+/-0.030	R 0.378	$\checkmark$		Rad b-	OK
0.500	+/-0.030		~		Celps	OFC-01
0.75	+/-0.030	0.755			1	4
						,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,

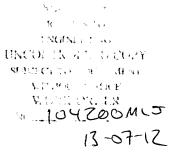
		2AQ		
Measured by: JFC	Audited by:	(44)	Preliminary Approval:	
Date: 2013-07-24	Date:	13/07/20	Date:	

Rev	Date	Change	Revised by	Approved
	10.06.07	New Issue	KJ 😽	100

D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



**D4016-5 HINGE HALF, LIGHT LID** 

RELEASED 2010 -02- 16

A	NEW IS	EWISSUE			10.01.29
REV.		DESCRIPTION			DATE
DESIG	4	AJS	DART AEROSPACE LTD		TD
DRAWN		AJS	HAWKESBURY, ONTARIO, CANADA		
CHECK	ED	$\omega$	DRAWING NO.		REV. A
MFG. A	PPR.	<i>S</i>	D4016		SHEET 1 OF 2
APPRO	7,40		TITLE	··· <del>·</del>	
DE APPR.		#	BASKET HINGE		NTS
DATE 10.01.29			COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS IMPARTE AND CONSTICETION, AND IS SUPPLIED ON THE EUPPLES CONDITION THAT IT IS  HOT TO BE USED FOR ANY PURPOSE OR COMPANIONATION TO ANY PURPOSE WRITTEN PERMISSION FROM DART ARROSPACE LTD.		

D

С

0.875 -0.25 0.38+0.03 R0.38 Ø0.257 REF THRU GRAIN DIRECTION 0.88 0.50 0.13 R0.03 TYP - 0.75 -

**D4016-1 HINGE HALF, BASE** 

0.250 0.50 R0.03 0.13 R0.31 --- 0.563 -REF 0.63 Ø0.257 THRU

GRAIN DIRECTION

0.13

**D4016-3 HINGE HALF, LID D4016-5 HINGE HALF, LIGHT LID** 

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	0	DRAWING NO.	REV. A
MFG. APPR.		D4016	SHEET 2 OF 2
APPROVED	10	TITLE	SCALE
DE APPR.	-44	TBASKET HINGE	NTS
DATE 10.0	1.29	COPYRIGHT 0: 2010 BY DART AEROSPACE LTD THE DOCUMENT IS PRINTY AND COMPREYING AND IS SUPPLED ON THE EXPRESS ORIGINATION THAT IT IS NOT TO \$6 USED FOR ANY PRIMAGE OF COPIC OR COMPANIENT TO TO ANY OTHER PRISON WITHOUT	

NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR, PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B

Α

REF DART SPEC M6061T6B

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 lbs
-5: 0.01 lbs

